



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3234-1

Job Sheet 216203



Part No: D3234-1

Job Qty: 4 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/3/20

Job Tracking No:

Due Date: 12/23/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP Rev:A New Issue 08-08-14 JLM Verified By:EC IPP Rev:B 08-12-18 as per ECN08-582 DD
verified by:EC IPP REV:C 11.11.24 AS PER ECN11-674 DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs		12/22/20	0.17	0.36	Waterjet - Flow		20/12/22
110	QC 2	4 pcs		12/22/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		20/12/22
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

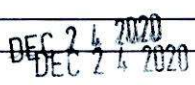
Plex 12/3/20 9:33 AM Dart.lajeunesse.marie

				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
120	QC 8	4 pcs	12/22/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
					QC 8 - 81
130	Handfinish - 1-1 Chemical-B4B	4 pcs	12/23/20	0.00 0.18	Handfinish - 1 - 1 - B4B
					Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B

DAS
DEC 22 2020 40
39

BFB 24/12/2020

					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
140 QC 7	4 pcs	12/23/20	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	DAS DEC 24 2020 2:50
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
					QC 7 - 83	
					QC 7 - 82	
					QC 7 - 87	
150 Packaging 3-1 - Stock - B4B	4 pcs	12/23/20	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS 28 7-89
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	DEC 24 2020
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	

				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 37 - B4B	
160 QC 21 - SA	4 pcs	12/23/20	0.00 0.00	QC 21 - SA - 21	 
				QC 21 - SA - 70	
				QC 21 - SA - 9	
				QC 21 - SA - 77	
				QC 21 - SA - 28	
Part Op 100 - 1-Cut as per Dwg Dwg Rev:  Prog Rev:  2-Deburr if necessary Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 130 - Chemical Conversion Coat per QSI005 4.1 140 - QC7-Inspect Chemical Conversion Coat 150 - Identify as per dwg & Stock Location: _____ 160 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M2024T3S.080	2024-T3 .080 Sheet	2.3200 sf (.58 ea)	100-Waterjet - Flow - 1	5176457	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M2024T3S.080	2	71	0	
Part Specifications					
Specifications could not be found.					

Plex 12/3/20 9:33 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 216203
Description: Doubler		Part Number: D3234-1
Inspection Dwg: D3234	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	Ø.099	1		✓ 2 pc. 04	
0.285	+/-0.010	.287	1		" "	
1.295	+/-0.010	1.296	1		" "	
2.305	+/-0.010	2.302	1		" "	
2.700	+/-0.010	2.700	1		" "	
4.505	+/-0.010	4.495	1		" "	
1.33	+/-0.030	1.33	1		" "	
1.523	+/-0.010	1.524	1		" "	
2.641	+/-0.010	2.645	1		" "	
3.758	+/-0.010	3.759	1		" "	
5.993	+/-0.010	5.994	1		" "	
7.111	+/-0.010	7.114	1		" "	
8.228	+/-0.010	8.229	1		✓ 2 pc. 01	
10.463	+/-0.010	10.465	1		" "	
10.77	+/-0.030	10.77	1		" "	
2.25	+/-0.030	2.246	1		✓ 2 pc. 04	
13.333	+/-0.010	13.333	1		Top	
15.366	+/-0.010	15.366	1		"	
15.665	+/-0.010	15.665	1		"	
0.080	+/-0.010	.079	1		✓ 2 pc. 04	

Measured by: <i>an</i>	Audited by: <i>40</i>	Preliminary Approval:
Date: 20/12/22	Date: DEC 22 2020	Date:

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	
B	09.05.04	Dimensions update per Rev B	KJ/DD	
C	12.02.01	Dimensions update per Rev C	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
Tel.: 1 613 692-8200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S323247

Part: D3234-1

Job No: 216203

Serial No/Batch: S323247

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/22/20